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Hurwitz et al.

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(54) **METHOD FOR FABRICATING EMBEDDED CHIPS**

25/0657; H01L 25/06; H01L 25/071; H01L 25/072; H01L 25/073; H01L 25/074; H01L 25/075; H01L 25/07

See application file for complete search history.

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H01L 25/075 (2006.01)

H01L 25/07 (2006.01)

H01L 25/065 (2006.01)

H01L 25/04 (2014.01)

(52) **U.S. Cl.**

CPC **H01L 25/00** (2013.01); **H01L 25/042** (2013.01); **H01L 25/0652** (2013.01); **H01L 25/071** (2013.01); **H01L 25/072** (2013.01); **H01L 25/0753** (2013.01)

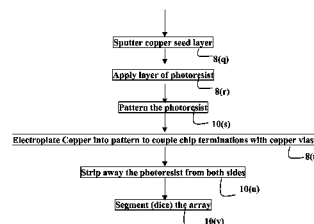
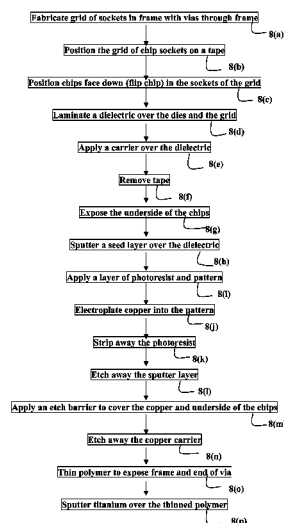
(58) **Field of Classification Search**

CPC H01L 25/00; H01L 25/03; H01L 25/04; H01L 25/041; H01L 25/042; H01L 25/043; H01L 25/047; H01L 25/048; H01L 25/065; H01L 25/0652; H01L 25/0655; H01L

(57) **ABSTRACT**

A method of fabricating embedded die packages including the following steps: obtaining a honeycomb array of chip sockets such that each chip socket is surrounded by a framework having a polymer matrix of a first polymer and at least one via post through the framework around each socket; placing the honeycomb array on a transparent tape so that an underside of the honey comb array contacts the transparent tape; positioning a chip terminal the down (flip chip) in each chip socket so that undersides of the dies contact the transparent tape; using optical imaging through the tape to align the chips with the via posts; applying a packing material over and around the chips in the honeycomb array, and curing the filler to embed the chips on five sides; thinning and planarizing the packing material to expose upper ends of the vias on upper side of the array; removing the transparent tape; applying a feature layer of conductors on the underside of the honeycomb array and the undersides of the chips, to couple at least one terminal of each die to at least one through via; applying a feature layer of conductors on over side of the honeycomb array such that at least one conductor extends from a through via at least partway over each chip; dicing the array to create separate dies comprising at least one embedded chip having a contract pad coupled to a through via adjacent the chip.

20 Claims, 13 Drawing Sheets



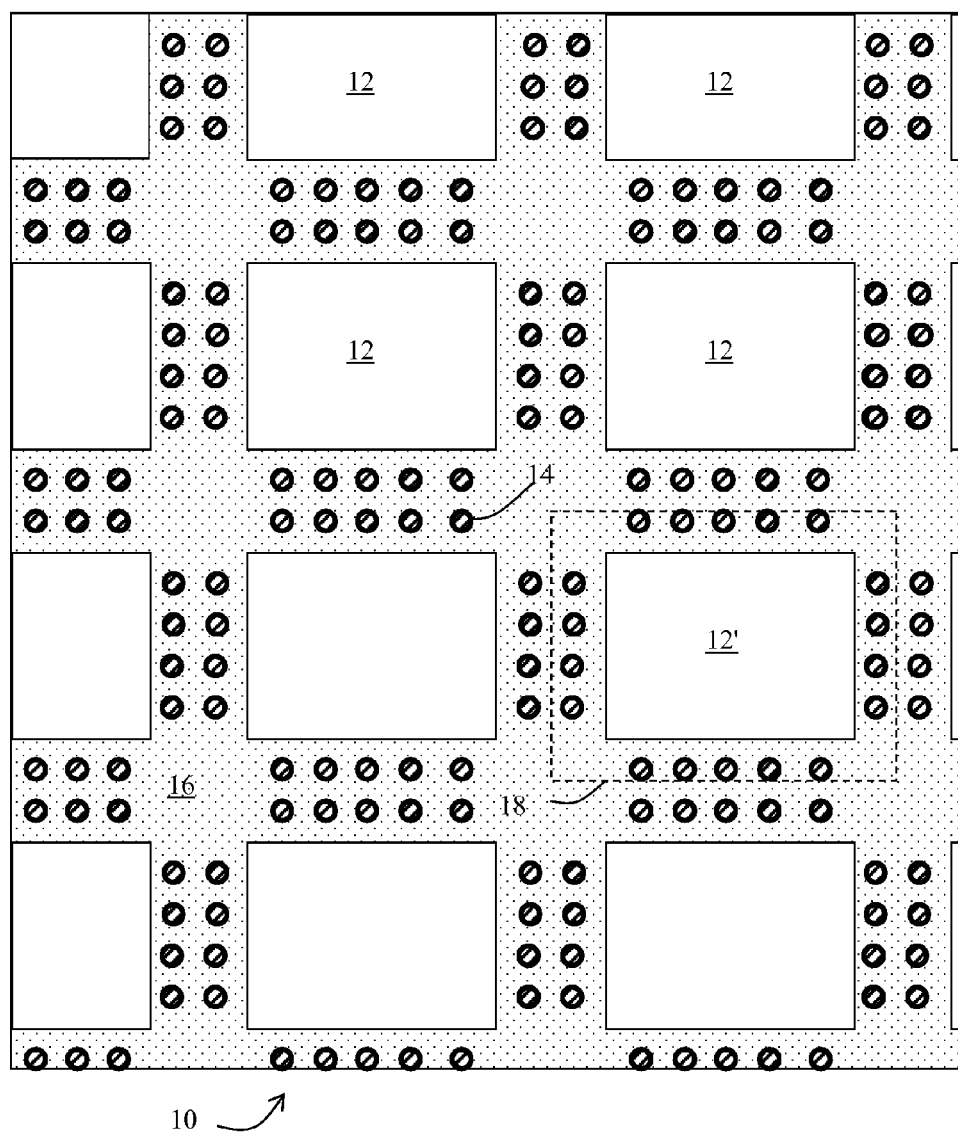


Fig. 1

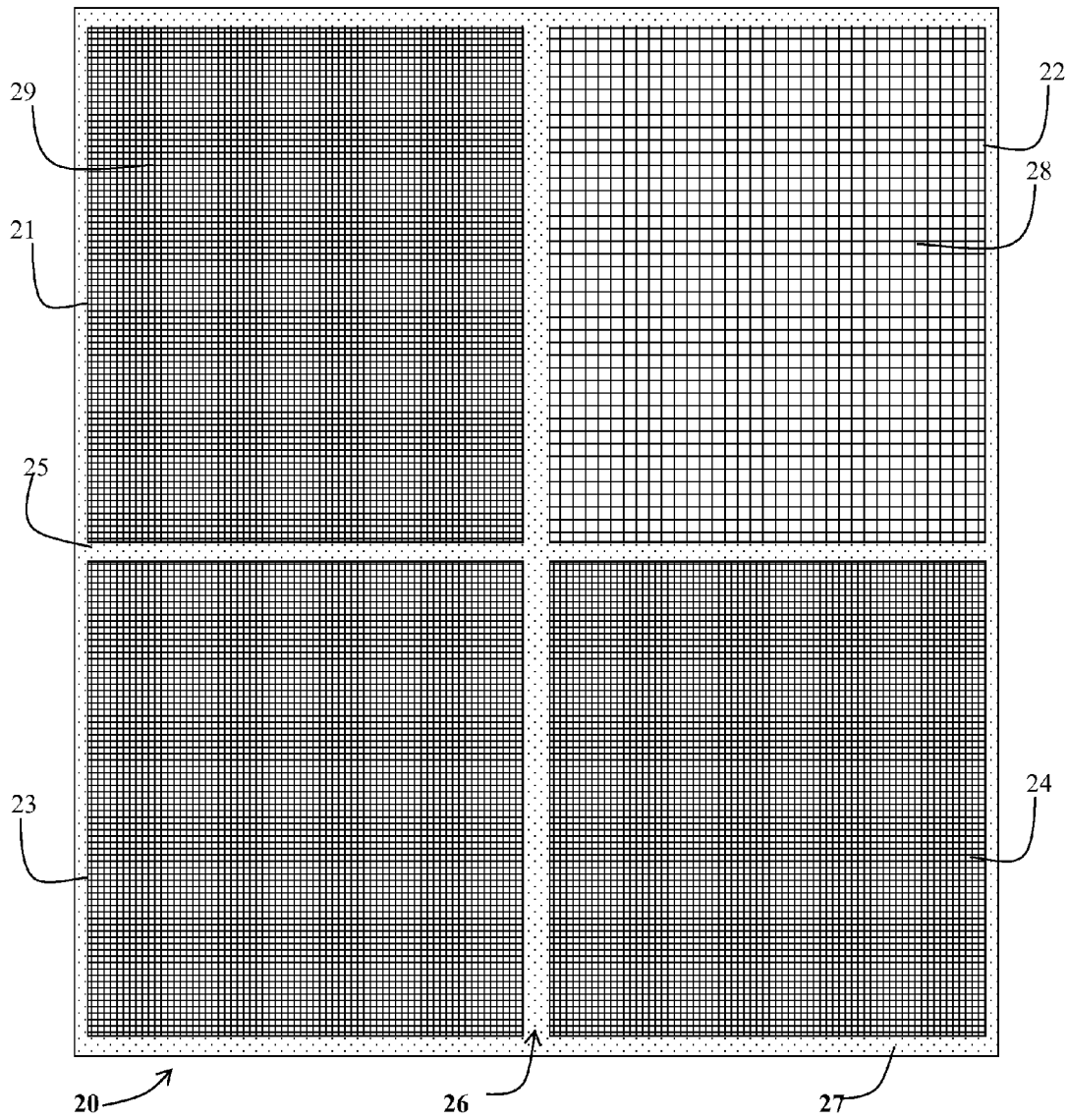


Fig. 2

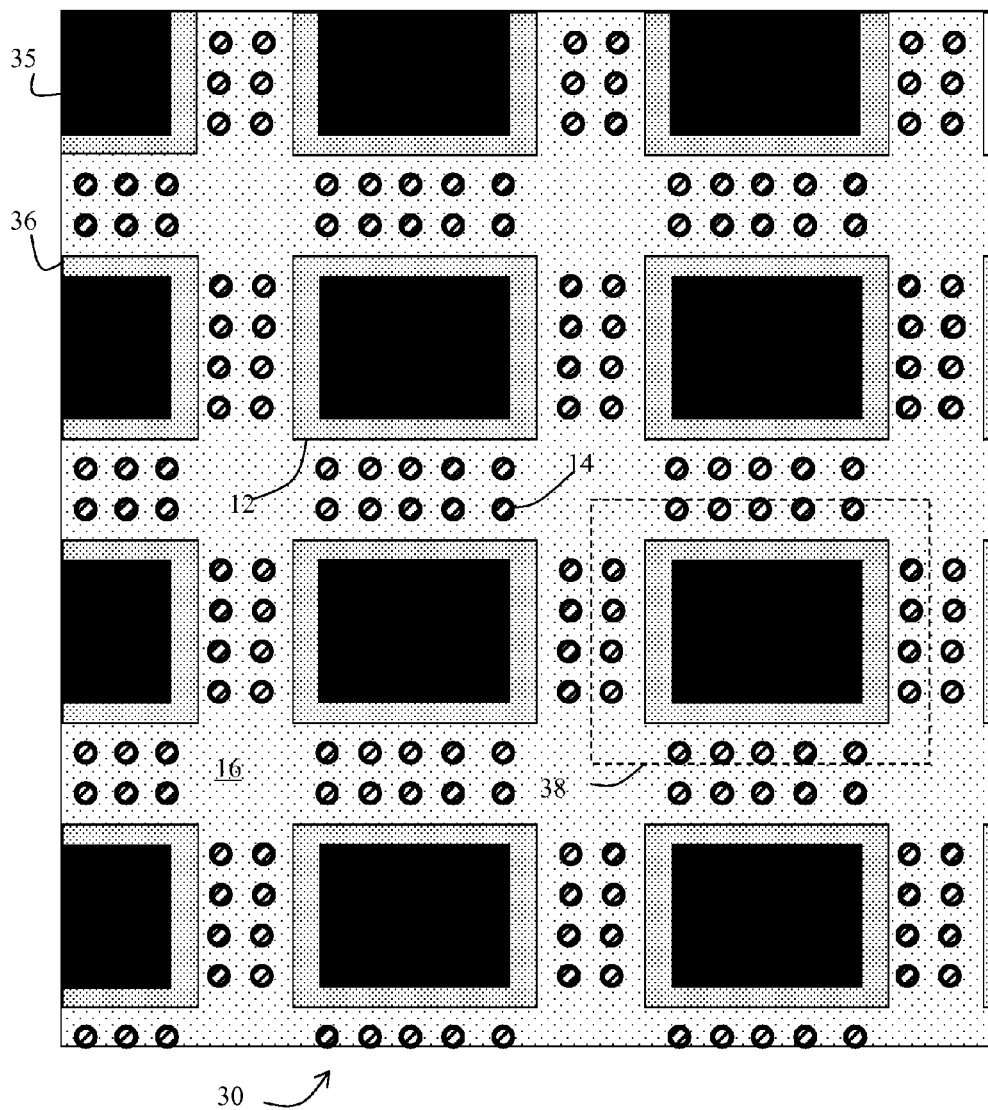


Fig. 3

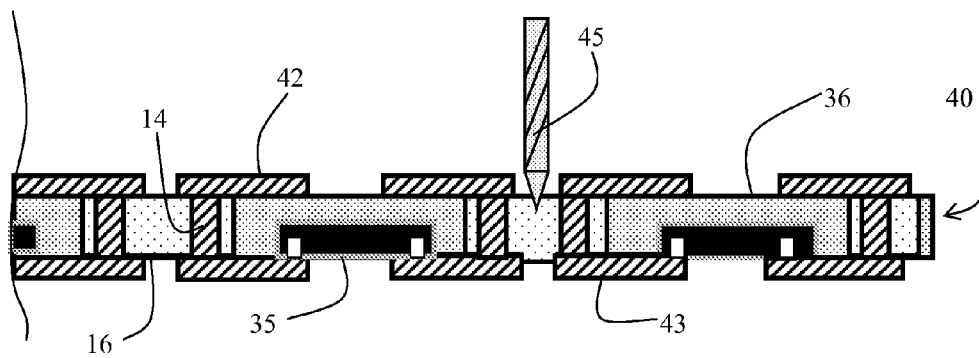


Fig. 4

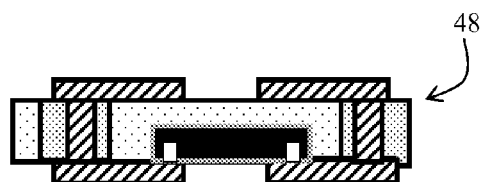


Fig. 5

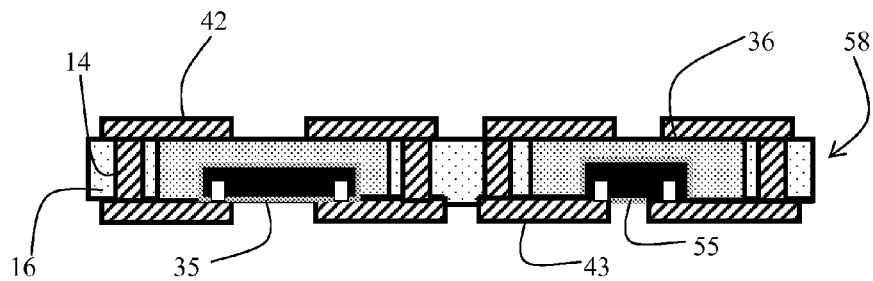


Fig. 6

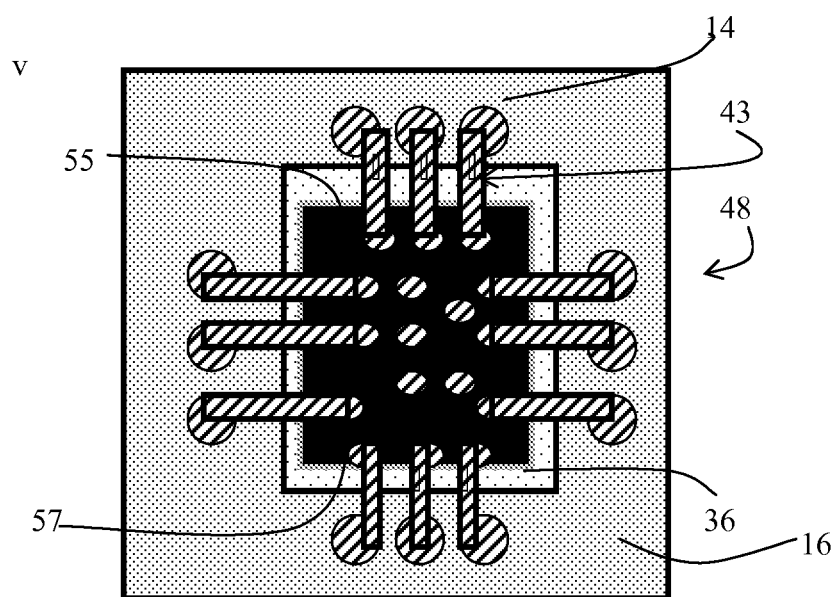


Fig. 7

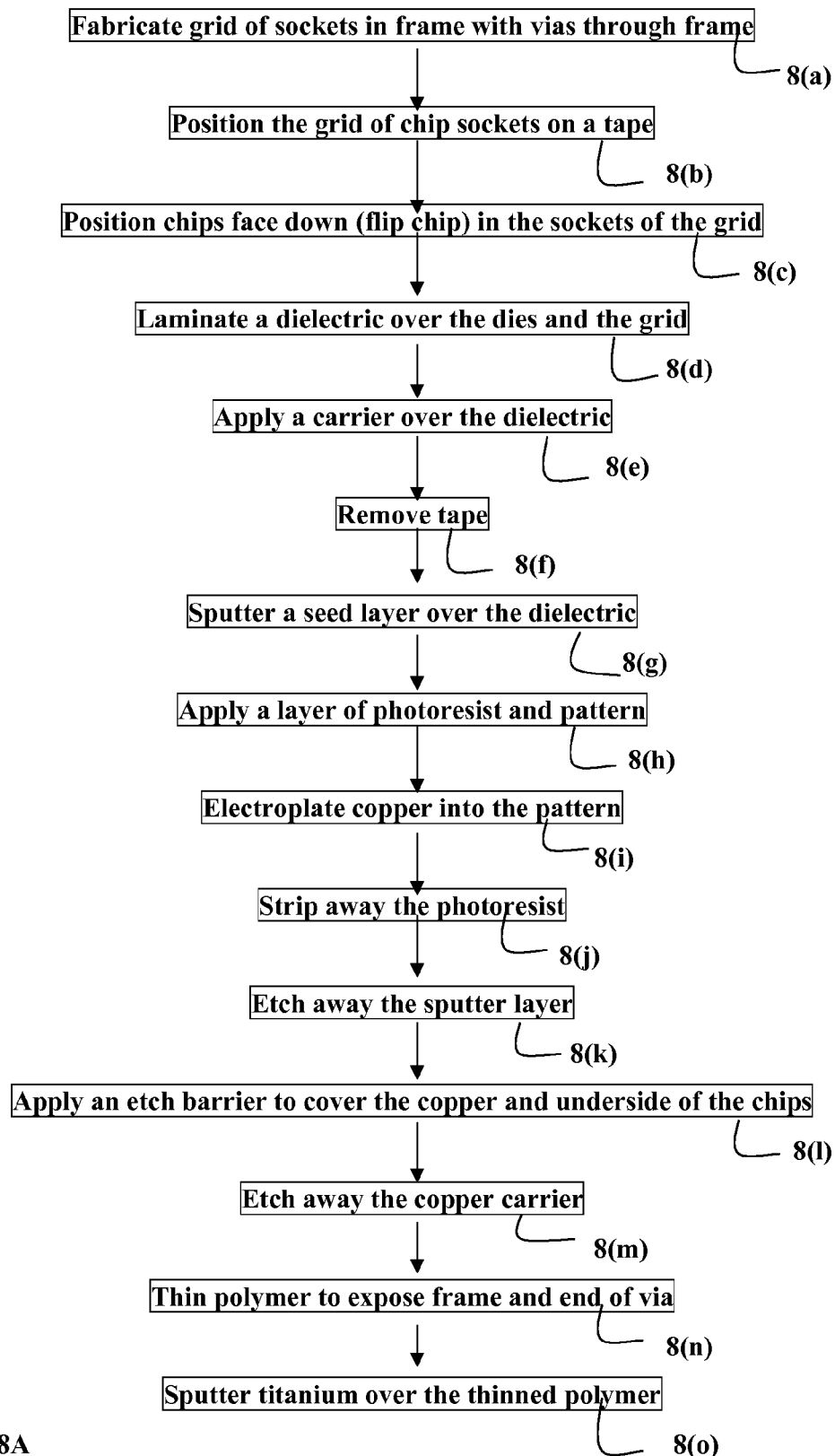


Fig. 8A

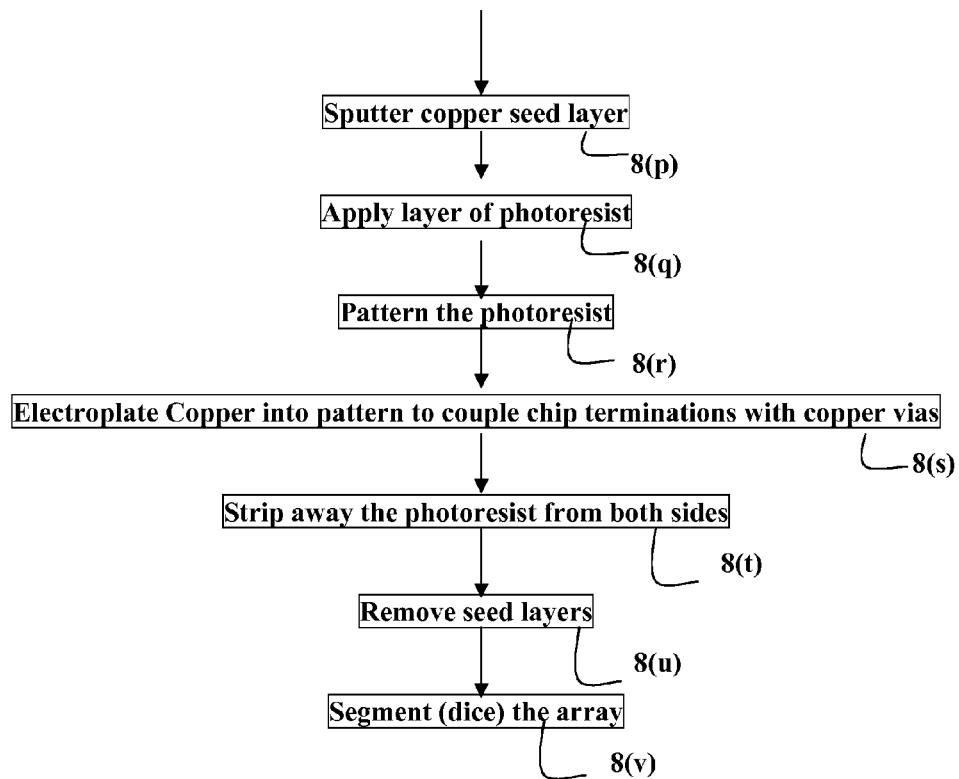


Fig. 8B

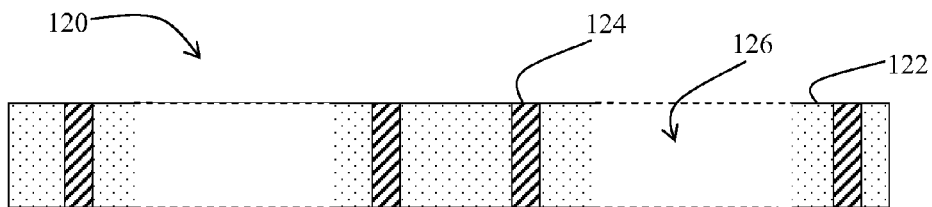


Fig. 8(a)

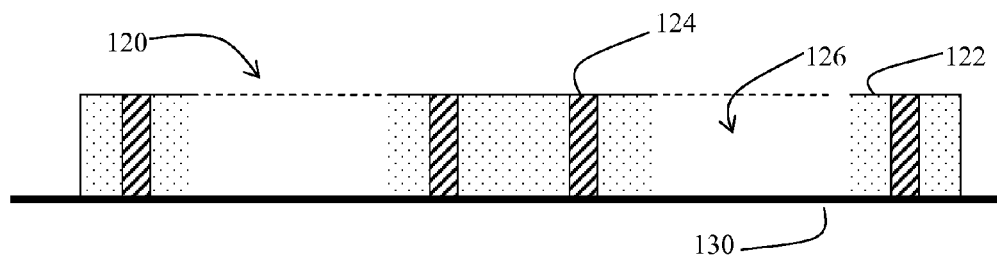


Fig. 8(b)

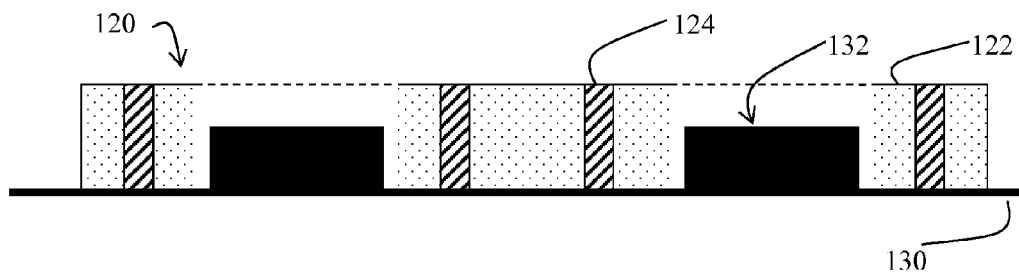


Fig. 8(c)

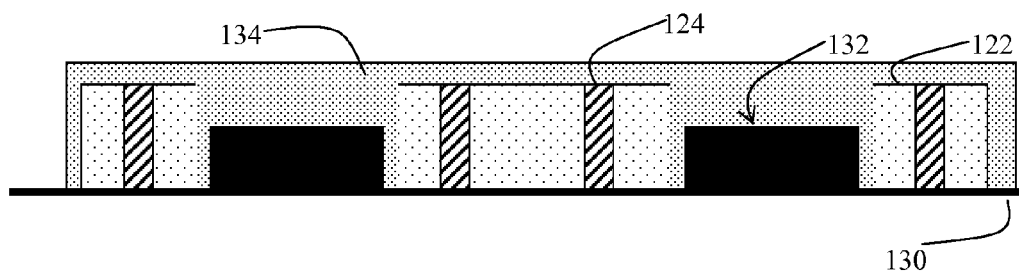


Fig. 8(d)

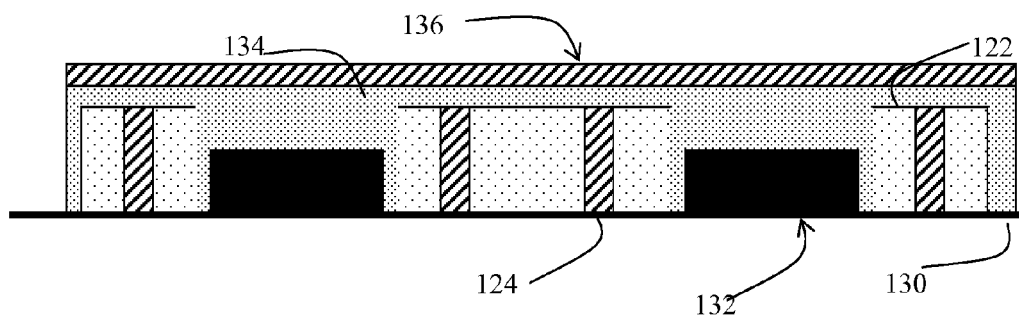


Fig. 8(e)

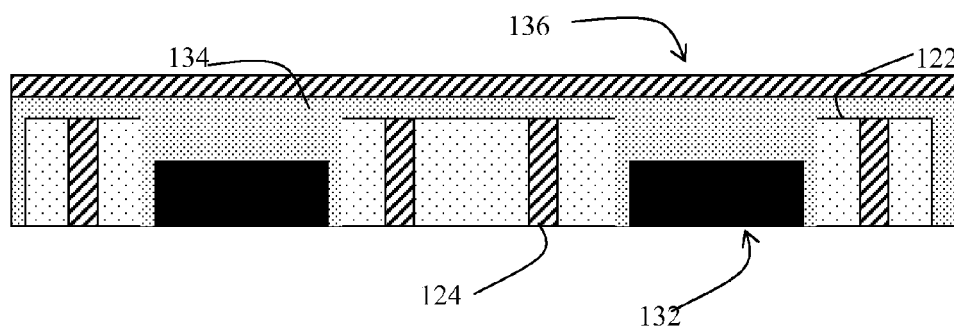


Fig. 8(f)

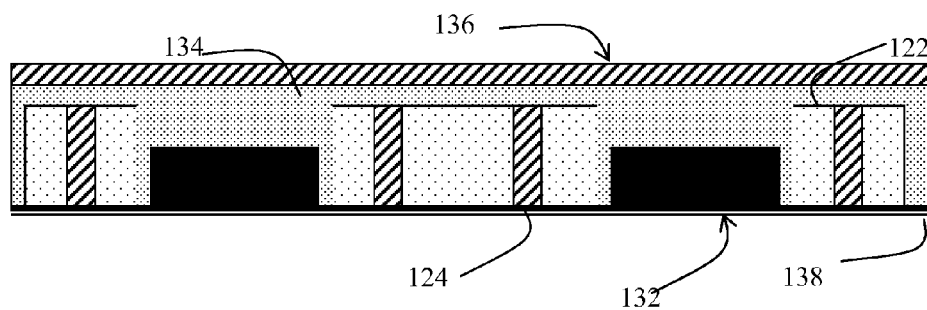


Fig. 8(g)

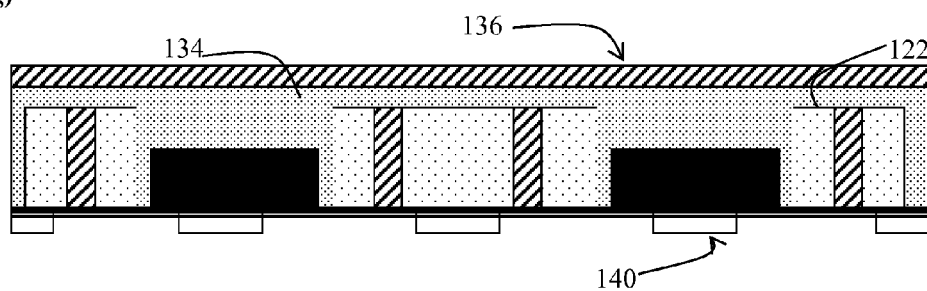


Fig. 8(h)

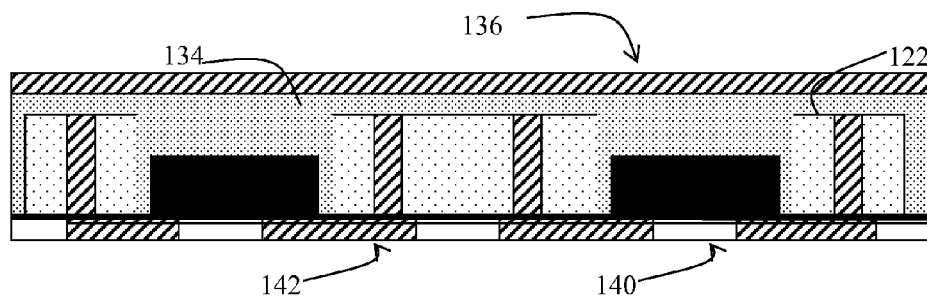


Fig. 8(i)

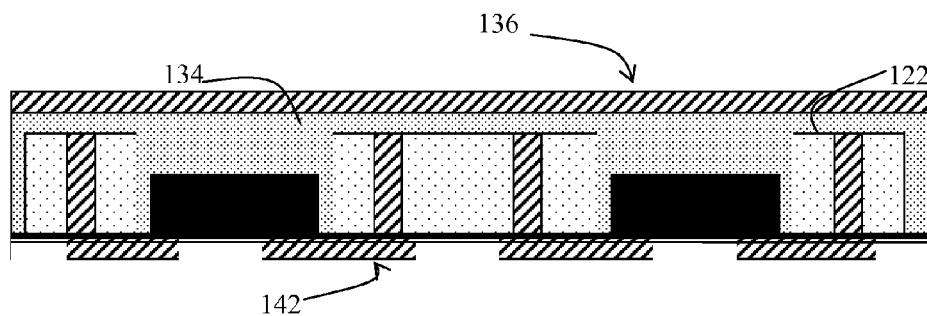


Fig. 8(j)

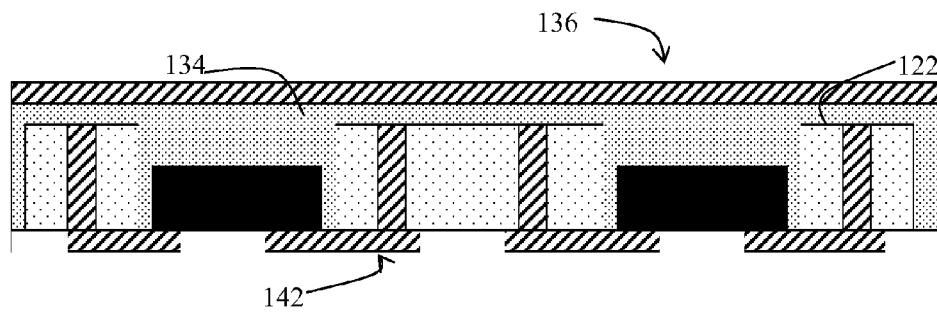


Fig. 8(k)

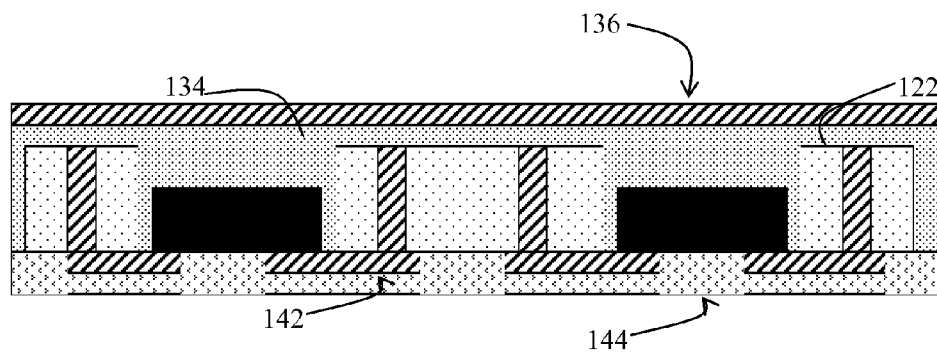


Fig. 8(l)

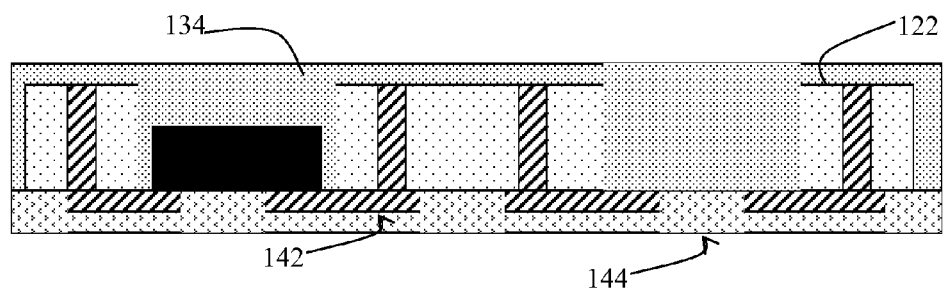


Fig. 8(m)

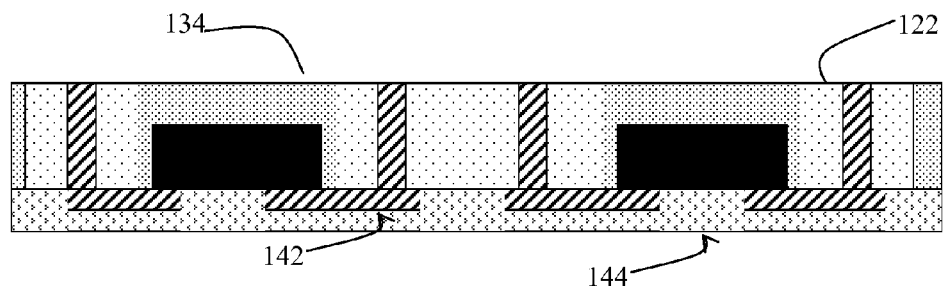


Fig. 8(n)

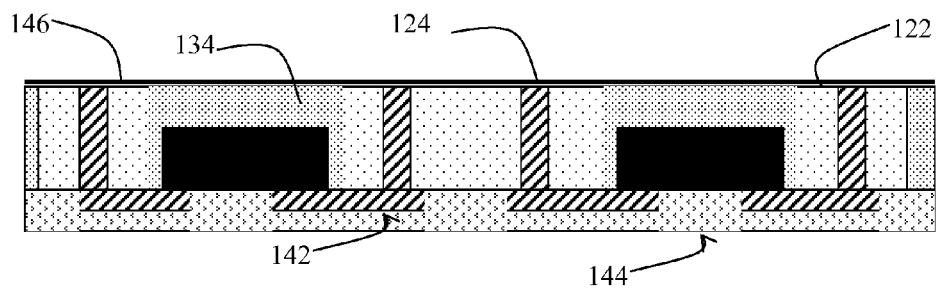


Fig. 8(o)

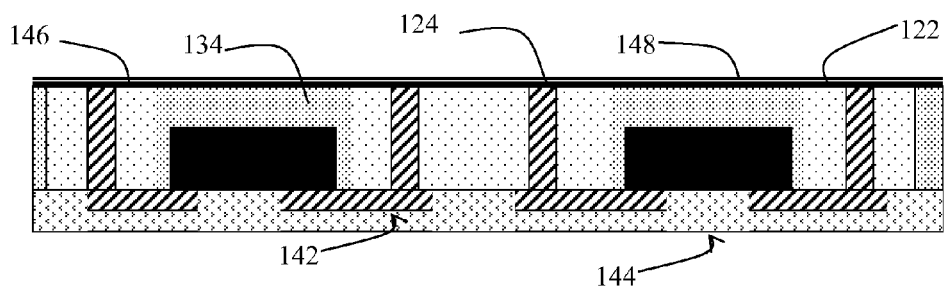


Fig. 8(p)

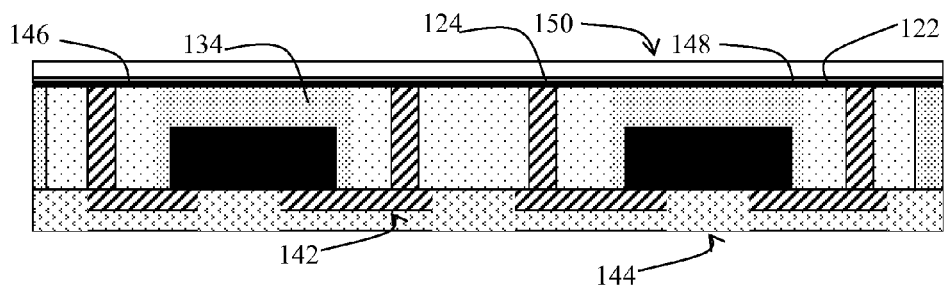


Fig. 8(q)

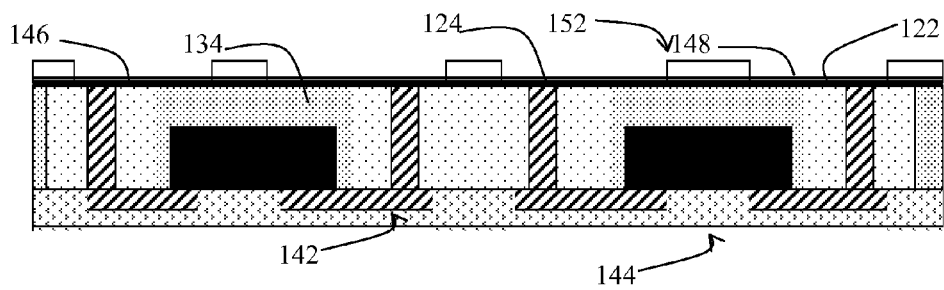


Fig. 8(r)

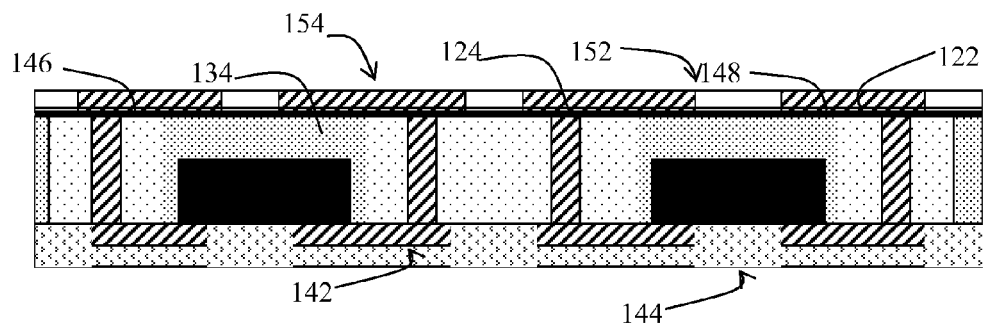


Fig. 8(s)

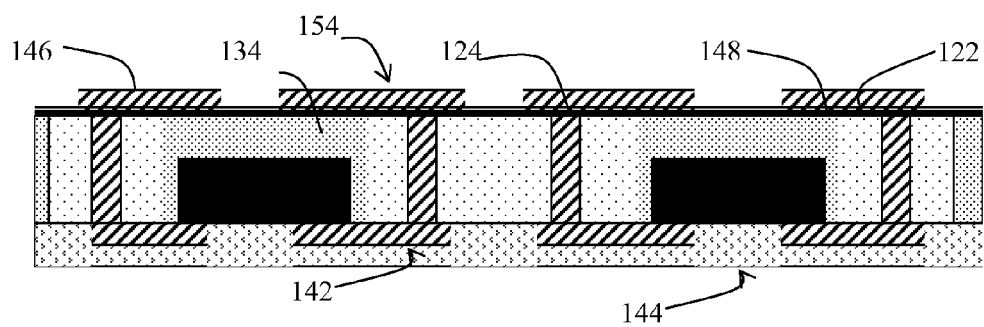


Fig. 8(t)

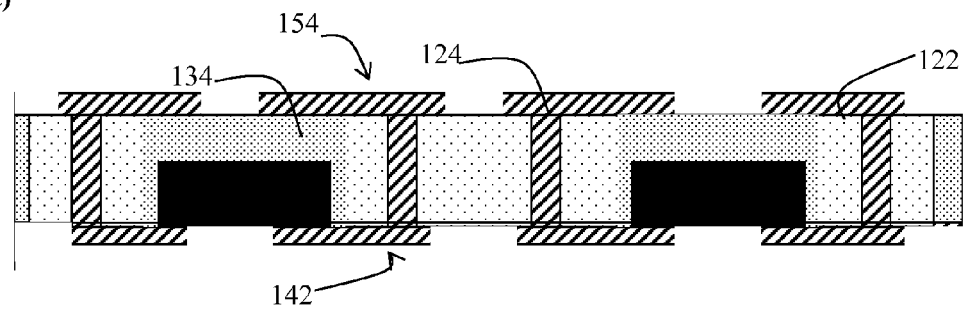


Fig. 8(u)

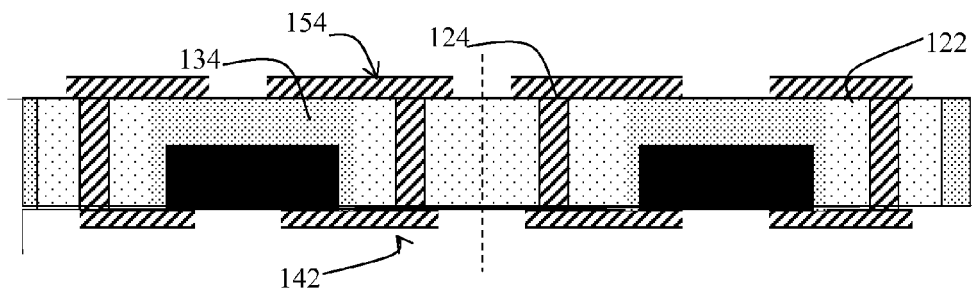


Fig. 8(v)

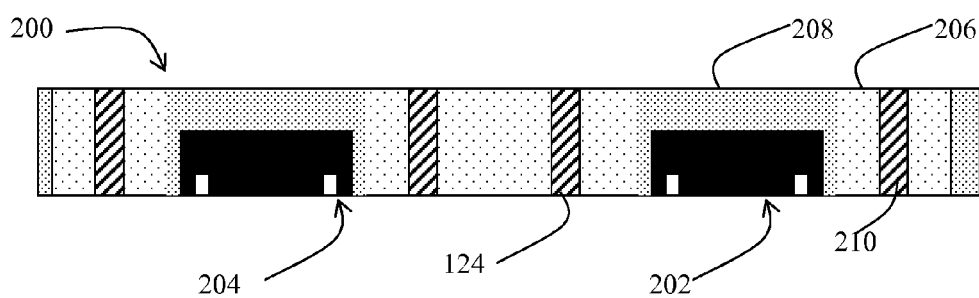


Fig. 9

1

METHOD FOR FABRICATING EMBEDDED CHIPS

BACKGROUND

1. Field of the Disclosure

The present invention is directed to chip packaging, specifically to embedded chips.

2. Description of the Related Art

Driven by an ever greater demand for miniaturization of ever more complex electronic components, consumer electronics such as computing and telecommunication devices are becoming ever more integrated. This has created a need for support structures such as IC substrates and IC interposers that have a high density of multiple conductive layers and vias that are electrically insulated from each other by a dielectric material.

The general requirement for such support structures is reliability and appropriate electrical performance, thinness, stiffness, planarity, good heat dissipation and a competitive unit price.

Of the various approaches for achieving these requirements, one widely implemented manufacturing technique that creates interconnecting vias between layers uses lasers to drill holes through the subsequently laid down dielectric substrate through to the latest metal layer for subsequent filling with a metal, usually copper, that is deposited therein by a plating technique. This approach to creating vias is sometimes referred to as 'drill & fill', and the vias created thereby may be referred to as 'drilled & filled vias'.

There are a number of disadvantages with the drilled & filled via approach. Since each via is required to be separately drilled, the throughput rate is limited, and the costs of fabricating sophisticated, multi-via IC substrates and interposers becomes prohibitive. In large arrays it is difficult to produce a high density of high quality vias having different sizes and shapes in close proximity to each other by the drill & fill methodology. Furthermore, laser drilled vias have rough side walls and taper inwards through the thickness of the dielectric material. This tapering reduces the effective diameter of the via. It may also adversely affect the electrical contact to the previous conductive metal layer especially at ultra small via diameters, thereby causing reliability issues. Additionally, the side walls are particularly rough where the dielectric being drilled is a composite material comprising glass or ceramic fibers in a polymer matrix, and this roughness may result in stray inductances.

The filling process of the drilled via holes is usually achieved by copper electroplating. Electroplating into a drilled hole may result in dimpling, where a small crater appears at the end of the via. Alternatively, overfill may result, where a via channel is filled with more copper than it can hold, and a domed upper surface that protrudes over the surrounding material is created. Both dimpling and overfill tend to create difficulties when subsequently stacking vias one on end of the other, as required when fabricating high-density substrates and interposers. Furthermore, it will be appreciated that large via channels are difficult to fill uniformly, especially when they are in proximity to smaller vias within the same interconnecting layer of the interposer or IC substrate design.

The range of acceptable sizes and reliability is improving over time. Nevertheless, the disadvantages described hereinabove are intrinsic to the drill & fill technology and are expected to limit the range of possible via sizes. It will further be noted that laser drilling is best for creating round via channels. Although slot shaped via channels may theoretically be fabricated by laser milling, in practice, the range of

2

geometries that may be fabricated is somewhat limited and vias in a given support structure are typically cylindrical and substantially identical.

Fabrication of vias by drill & fill is expensive and it is difficult to evenly and consistently fill the via channels created thereby with copper using the relatively, cost-effective electroplating process.

Laser drilled vias in composite dielectric materials are practically limited to a minimum diameter of 60×10^{-6} m, and even so suffer from significant tapering shape as well as rough side walls due to the nature of the composite material drilled, in consequence of the ablation process involved.

In addition to the other limitations of laser drilling as described hereinabove, there is a further limitation of the drill & fill technology in that it is difficult to create different diameter vias in the same layer, since when drill different sized via channels are drilled and then filled with metal to fabricate different sized vias, the via channels fill up at different rates. Consequently, the typical problems of dimpling or overfill that characterize drill & fill technology are exacerbated, since it is impossible to simultaneously optimize deposition techniques for different sized vias.

An alternative solution that overcomes many of the disadvantages of the drill & fill approach, is to fabricate vias by depositing copper or other metal into a pattern created in a photo-resist, using a technology otherwise known as 'pattern plating'.

In pattern plating, a seed layer is first deposited. Then a layer of photo-resist is deposited thereover and subsequently exposed to create a pattern, and selectively removed to make trenches that expose the seed layer. Via posts are created by depositing Copper into the photo-resist trenches. The remaining photo-resist is then removed, the seed layer is etched away, and a dielectric material that is typically a polymer impregnated glass fiber mat, is laminated thereover and therearound to encase the via posts. Various techniques and processes can then be used to planarize the dielectric material, removing part of it to expose the ends of the via posts to allow conductive connection to ground thereby, for building up the next metal layer thereupon. Subsequent layers of metal conductors and via posts may be deposited there onto by repeating the process to build up a desired multilayer structure.

In an alternative but closely linked technology, known hereinafter as 'panel plating', a continuous layer of metal or alloy is deposited onto a substrate. A layer of photo-resist is deposited over an end of the substrate, and a pattern is developed therein. The pattern of developed photo-resist is stripped away, selectively exposing the metal thereunder, which may then be etched away. The undeveloped photo-resist protects the underlying metal from being etched away, and leaves a pattern of upstanding features and vias.

After stripping away the undeveloped photo-resist, a dielectric material, such as a polymer impregnated glass fiber mat, may be laminated around and over the upstanding copper features and/or via posts. After planarizing, subsequent layers of metal conductors and via posts may be deposited there onto by repeating the process to build up a desired multilayer structure.

The via layers created by pattern plating or panel plating methodologies described above are typically known as 'via posts' and feature layers from copper.

It will be appreciated that the general thrust of the micro-electronic evolution is directed towards fabricating ever smaller, thinner, lighter and more powerful products having high reliability. The use of thick, cored interconnects, prevents ultra-thin products being attainable. To create ever

higher densities of structures in the interconnect IC substrate or 'interposer', ever more layers of ever smaller connections are required.

If plated, laminated structures are deposited on a copper or other appropriate sacrificial substrate, the substrate may be etched away leaving free standing, coreless laminar structures. Further layers may be deposited on the side previously adhered to the sacrificial substrate, thereby enabling a two sided build up, which minimizes warping and aids the attaining of planarity.

One flexible technology for fabricating high density interconnects is to build up pattern plated or panel plated multilayer structures consisting of metal vias or via post features having various geometrical shapes and forms in a dielectric matrix. The metal may be copper and the dielectric may be a film polymer or a fiber reinforced polymer. Typically a polymer with a high glass transition temperature (T_g) is used, such as polyimide or epoxy, for example. These interconnects may be cored or coreless, and may include cavities for stacking components. They may have odd or even numbers of layers and the vias may have non circular shapes. Enabling technology is described in previous patents issued to Amitec-Advanced Multilayer Interconnect Technologies Ltd.

For example, U.S. Pat. No. 7,682,972 to Hurwitz et al. titled "Advanced multilayer coreless support structures and method for their fabrication" describes a method of fabricating a free standing membrane including a via array in a dielectric, for use as a precursor in the construction of superior electronic support structures. The method includes the steps of fabricating a membrane of conductive vias in a dielectric surround on a sacrificial carrier, and detaching the membrane from the sacrificial carrier to form a free standing laminated array. An electronic substrate based on such a free standing membrane may be formed by thinning and planarizing the laminated array, followed by terminating the vias. This publication is incorporated herein by reference in its entirety.

U.S. Pat. No. 7,669,320 to Hurwitz et al. titled "Coreless cavity substrates for chip packaging and their fabrication" describes a method for fabricating an IC support for supporting a first IC die connected in series with a second IC die; the IC support comprising a stack of alternating layers of copper features and vias in insulating surround, the first IC die being bondable onto the IC support, and the second IC die being bondable within a cavity inside the IC support, wherein the cavity is formed by etching away a copper base and selectively etching away built up copper. This publication is incorporated herein by reference in its entirety.

U.S. Pat. No. 7,635,641 to Hurwitz et al. titled "Integrated circuit support structures and their fabrication" describes a method of fabricating an electronic substrate comprising the steps of; (A) selecting a first base layer; (B) depositing a first etchant resistant barrier layer onto the first base layer; (C) building up a first half stack of alternating conductive layers and insulating layers, the conductive layers being interconnected by vias through the insulating layers; (D) applying a second base layer onto the first half stack; (E) applying a protective coating of photo-resist to the second base layer; (F) etching away the first base layer; (G) removing the protective coating of photo-resist; (H) removing the first etchant resistant barrier layer; (I) building up a second half stack of alternating conductive layers and insulating layers, the conductive layers being interconnected by vias through the insulating layers, wherein the second half stack has a substantially symmetrical lay up to the first half stack; (J) applying an insulating layer onto the second half stack of alternating conductive layers and insulating layers, (K) removing the second base

layer, and (L) terminating the substrate by exposing ends of vias on outer surfaces of the stack and applying terminations thereto. This publication is incorporated herein by reference in its entirety.

The via post technology described in U.S. Pat. No. 7,682,972, U.S. Pat. No. 7,669,320 and U.S. Pat. No. 7,635,641 lends itself to mass production, with very large numbers of vias being simultaneously electroplated. As mentioned above, current drill & fill vias have an effective minimal diameter of about 60 microns. In contradistinction, via post technology using photo resist and electroplating, enables much higher densities of vias to be obtained. Via diameters of as little as 30 micron diameter are possible and various via geometries and shapes could be cofabricated within the same layer.

Over time, it is anticipated that both drill & fill technologies and via post deposition will enable fabrication of substrates with further miniaturization and higher densities of vias and features. Nevertheless, it would appear likely that developments in via post technology will maintain a competitive edge.

Substrates enable chips to interface with other components. Chips have to be bonded to substrates through assembly processes that provide reliable electronic connections to enable electronic communication between chips and substrates.

Embedding chips within the interposers to the outside world enables shrinking the chip package, shortening the connections to the outside world, offers cost savings by simpler manufacturing that eliminates die to substrate assembly processes and potentially has increased reliability.

Essentially, the concept of embedding active components such as analog, digital and MEMS chips involves the construction of chip support structures or substrates, having vias around the chip.

One way of achieving embedded chips is to fabricate chip support structures onto the chip array on the wafer where the circuitry of the support structure is larger than the die unit size. This is known as Fan Out Wafer Layer Packaging (FOWLP). Although the size of silicon wafers is growing, expensive material sets and manufacturing process are still limiting the diameter size to 12", thereby limiting the number of FOWLP units one can place on the wafer. Despite the fact that 18" wafers are under consideration, the investment required, materials sets and equipment are still unknown. The limited number of chip support structures that may be processed at one time increases the unit cost of FOWLP, and make it too expensive for markets requiring highly competitive pricing, such as wireless communication, home appliances and automotive markets.

FOWLP also represents a performance limitation since the metal features placed over the silicon wafer as fan-out or fan-in circuitry are limited in thickness to a few microns. This creates electrical resistance challenges.

An alternative fabrication route involves sectioning the wafer to separate the chips and embedding the chips within a panel consisting of dielectric layers with copper interconnects. One advantage of this alternative route is that the panels may be very much larger with very many more chips embedded in a single process. For example, whereas for example, a 12" wafer enables 2,500 FOWLP chips having dimensions of 5 mm×5 mm to be processed in one go, current panels used the applicant, Zhuhai Access, are 25"×21", enabling 10,000 chips to be processed in one go. Since the price of processing such panels is significantly cheaper than on wafer processing,

and since to throughput per panel is 4× higher than throughput on wafer, the unit cost can drop significantly, thereby opening new markets.

In both technologies, the line spacing and the width of the tracks used in industry are shrinking over time, with 15 micron going down to 10 microns being standard on panels and 5 microns going down to 2 microns on wafers.

The advantages of embedding are many. First level assembly costs, such as wire bonding, flip chip or SMD (Surface Mount Devices) soldering, are eliminated. The electrical performance is improved since the die and substrate are seamlessly connected within a single product. The packaged dies are thinner, giving an improved form factor, and the upper surface of the embedded die package is freed up for other uses including stacked die and PoP (Package on Package) technologies.

In both FOWLP and Panel based embedded die technologies, the chips are packaged as an array (on wafer or panel), and, once fabricated, are separated by dicing.

Embodiments of the present invention address fabricating embedded chip packages.

BRIEF SUMMARY

A method of fabricating embedded die packages comprising: obtaining an array of chip sockets such that each chip socket is surrounded by a framework having a polymer matrix of a first polymer and at least one via post through the framework around each socket; placing said honeycomb array on a transparent tape so that an underside of the array contacts said transparent tape; positioning a chip terminal said down in each chip socket so that undersides of said dies contact said transparent tape; using optical imaging through the tape to align said chips with said via posts; applying a packing material over and around said chips in said array, and curing the filler to embed the chips on five sides; thinning and planarizing the packing material to expose upper ends of said vias on upper side of said array; removing the transparent tape; applying a feature layer of conductors on said underside of said array and said undersides of the chips, to couple at least one terminal of each die to at least one through via; applying a feature layer of conductors on over side of said array such that at least one conductor extends from a through via at least partway over each chip; dicing said array to create separate dies comprising at least one embedded chip having a contract pad coupled to a through via adjacent said chip.

Typically, the array comprises an array of oblong cells.

Typically, the chips comprise at least one of analog processors, digital processors, sensors, filters and memories.

Preferably, the framework comprises glass fiber reinforcements in said first polymer.

Optionally, the framework comprises a weave of glass fiber bundles in said first polymer.

Typically, the packing material comprises a second polymer matrix.

Typically, the packing material comprises a molding compound.

Typically, the packing material comprises at least one polymer sheet that is laid over the framework and chips and is hot pressed.

Typically, the packing material further comprises at least one of a particle filler and a chopped fiber filler.

In one methodology, the honeycomb array is fabricated by: obtaining a sacrificial carrier; laying down a layer of photoresist; patterning the photoresist with a grid of copper vias; plating copper via posts into the grid; stripping away the photoresist laminating the copper via posts with a polymer

dielectric; thinning and planarizing the polymer dielectric to expose ends of the copper vias; removing the carrier, and machining chip sockets in the polymer dielectric.

Optionally, the sacrificial carrier is a copper carrier that is removed by dissolving the copper.

Typically, the method comprises applying an etch-resistant layer over the carrier prior to depositing copper vias.

Preferably, the etch resistant layer comprises nickel.

Optionally, the planarized polymer dielectric with exposed ends of copper vias is protected with an etch resistant material whilst copper carrier is etched away.

In some embodiments, the etch resistant material is a photoresist.

Typically, a copper seed layer is electroplated over the nickel.

Optionally, a copper seed layer is electroplated prior to depositing the nickel barrier layer.

In some embodiments, the polymer dielectric further comprises a weave of bundles of glass fibers and is applied as a pre-preg and is then cured.

An alternative methodology of fabricating the honeycomb array comprises: obtaining a sacrificial carrier; laying down a layer of photoresist; patterning the photoresist with a grid of copper vias and with an array of sockets; plating copper via posts into the grid and the array; stripping away the photoresist; laminating the copper via posts and the array with a polymer dielectric; thinning and planarizing the polymer dielectric to expose ends of copper vias and array; shielding the ends of the copper vias and selectively dissolving the array to form the sockets, and removing the carrier.

An alternative methodology of fabricating the honeycomb array comprises: obtaining a substrate comprising a copper clad polymer matrix; drilling an array of via holes; electroplating copper into the via holes; removing copper cladding, and machining sockets through the substrate.

Typically, the step of removing the copper cladding comprises at least one of dissolving, abrasion and plasma etching.

Optionally, the polymer matrix further comprises glass fibers.

Optionally, the step of machining away sockets comprises at least one of punching and CNC.

BRIEF DESCRIPTION OF THE DRAWINGS

For a better understanding of the invention and to show how it may be carried into effect, reference will now be made, purely by way of example, to the accompanying drawings.

With specific reference now to the drawings in detail, it is stressed that the particulars shown are by way of example and for purposes of illustrative discussion of the preferred embodiments of the present invention only, and are presented in the cause of providing what is believed to be the most useful and readily understood description of the principles and conceptual aspects of the invention. In this regard, no attempt is made to show structural details of the invention in more detail than is necessary for a fundamental understanding of the invention; the description taken with the drawings making apparent to those skilled in the art how the several forms of the invention may be embodied in practice. In the accompanying drawings:

FIG. 1 is schematic illustration of a part of a polymer or composite grid having sockets therein for chips, and also having through vias around the sockets;

FIG. 2 is a schematic illustration of a panel used for fabricating embedded chips with surrounding through vias, showing how part of the panel, such as one pane may have sockets for a different type of chip;

7

FIG. 3 is schematic illustration of the part of the polymer or composite framework of FIG. 1, with chips within each socket, held in place by a polymer or composite material, such as a moulding compound, for example;

FIG. 4 is a schematic illustration of a cross-section through part of the framework showing embedded chips held within each socket by a polymer material, and also showing through vias and pads on both sides of the panel;

FIG. 5 is a schematic illustration of a cross-section through a die containing an embedded chip;

FIG. 6 is a schematic illustration of a cross-section through a package containing a pair of dissimilar dies in adjacent sockets;

FIG. 7 is a schematic bottom view of a package such as that shown in FIG. 5;

FIGS. 8A-B shows how sockets may be fabricated in the panel produced by the process of FIGS. 8A-B, and how chips may be inserted into the sockets, coupled to the outside world and then sectioned into individual packages with embedded chips;

The FIGS. 8(a) to 8(v) schematically show the intermediate structures obtained by the process of FIGS. 8A-B, and

FIG. 9 is a schematic cross section of part of an array of embedded dies.

DETAILED DESCRIPTION

In the description herein below, support structures consisting of metal vias in a dielectric matrix, particularly, copper via posts in a polymer matrix, such as polyimide, epoxy or BT (Bismaleimide/Triazine) or their blends, reinforced with glass fibers are considered.

It is a feature of Access' photo-resist and pattern or panel plating and laminating technology, as described in U.S. Pat. No. 7,682,972, U.S. Pat. No. 7,669,320 and U.S. Pat. No. 7,635,641 to Hurwitz et al., incorporated herein by reference, that large panels comprising very large arrays of substrates with very many via posts may be fabricated. Such panels are substantially flat and substantially smooth.

It is a further feature of Access' technology that vias fabricated by electroplating using photoresist, may be narrower than vias created by drill & fill. At present, the narrowest drill & fill vias are about 60 microns. By electroplating using photoresist, a resolution of under 50 microns, or even as little as 30 microns is achievable. Coupling ICs to such substrates is challenging. One approach for flip chip coupling is to provide copper pads that are flush with the surface of the dielectric. Such an approach is described in U.S. Ser. No. 13/912,652 to the present inventors.

All methods for attaching chips to interposers are costly. Wire bonding and flip chip technologies are costly and broken connections result in failure.

With reference to FIG. 1, there is shown part of an array 10 of chip sockets 12 defined by a framework 16 comprising a polymer matrix 16 and an array of metal vias 14 through the polymer matrix framework 16.

The array 10 may be part of a panel comprising an array of chip sockets, each surrounded and defined by a polymer matrix framework comprising a grid of copper vias through the polymer matrix framework.

Each chip socket 12 is thus surrounded by a frame 18 of polymer with a number of copper through vias through the frame 18, arranged around the socket 12.

The frame 18 may consist of a polymer applied as a polymer sheet, or may be a glass fiber reinforced polymer, applied as a prepreg. It may have one or more layers.

8

With reference to FIG. 2, the applicant, Zhuhai Access' panels 20 are typically divided into a 2x2 array of blocks 21, 22, 23, 24 separated from each other by a main frame consisting of a horizontal bar 25 a vertical bar 26 and an external frame 27. The blocks comprise array of chip sockets 12 FIG. 1) Assuming a 5 mmx5 mm chip size and Access' 21"x25" panels, this manufacturing technique enables 10,000 chips to be packaged on each panel. In contradistinction, fabricating chip packages on a 12" wafer, which is currently the largest wafer used in industry, enables only 2,500 chips to be processed in one go, so the economies of scale in fabricating on large panels will be appreciated.

Panels appropriate for this technology, may, however, vary in size somewhat. Typically, panels vary in size between about 12"x12" and about 24"x30". Some standard sizes in current use are 20"x16", and 25"x21".

Not all the blocks of the panel 20 need to have chip sockets 12 of the size time. For example, in the schematic illustration of FIG. 2, the chip sockets 28 of the top right block 22 are larger than the chip sockets 29 of the other blocks 21, 23, 24. Furthermore, not only may one or more blocks 22 be used for a different sized socket for receiving a different sized chip, but any sub array of any size may be used to fabricate any specific die package, so despite the large throughputs, small runs of small numbers of die packages may be fabricated, enabling different die packages to be simultaneously processed for a specific customer, or different packages to be fabricated for different customers. Thus a panel 20 may comprise at least one region 22 having sockets 28 with a first set of dimensions for receiving one type of chip, and a second region 21 having sockets 29 with a second set of dimensions for receiving a second type of chip.

As described hereinabove with reference to FIG. 1, each chip socket 12 (28, 29 FIG. 2) is surrounded by a polymer frame 18 and in each block (21, 22, 23, 24—FIG. 2), an array of sockets 28 (29) are positioned.

With reference to FIG. 3, a chip 35 may be positioned in each socket 12, and the space around the chip 35 may be filled in with a packing material 36 which may or may not be the same polymer as that used for fabricating the frame 16. It may be a molding compound for example. In some embodiments, the matrix of the packing material 36 and that of the frame 16 may use similar polymers. The polymer matrix of the frame may include continuous reinforcing fibers, whereas the polymer of the packing material 36 used for filling in the socket cannot include continuous fibers. However, the packing material 36 may include a filler which may include chopped fibers or ceramic particles, for example.

Typical die sizes may be anything from about 1 mmx1 mm, up to about 60x60 mm, with the sockets slightly larger by 0.1 mm to 2.0 mm from each side of the die to accommodate the intended dies with clearance. The thickness of the interposer frame must be at least the depth of the die, and is preferably 10 microns to 100 microns thicker. Typically, the depth of the frame is the thickness of the die+ a further 20 microns. The die thickness itself can range from 25 microns to 400 microns with typical values around 100 microns.

As a result of the embedding of chips 35 into the sockets 12, each individual chip is surrounded by a frame 38 having vias 14 there-through, arranged around the edges of each die.

Using Access' via post technology, either by pattern plating or by panel plating followed by selective etching, the vias 14 may be fabricated as via posts and subsequently laminated with a dielectric material, using polymer films, or, for added stability, prepregs consisting of woven glass fiber bundles in a polymer matrix. In one embodiment, the dielectric material is Hitachi 705G. In another embodiment, MGC 832 NXA

NSFLCA is used. In a third embodiment, Sumitomo GT-K may be used. In another embodiment, Sumitomo LAZ-4785 series films are used. In another embodiment, Sumitomo LAZ-6785 series is used. Alternative materials include Taiyo's HBI and Zaristo-125 or Ajinomoto's ABF GX material series.

Alternatively, the vias may be fabricated using what is generally known as drill-fill technology. First a substrate is fabricated, and then, after curing, it is drilled with holes, either by mechanical or by laser drilling. The drilled holes may then be filled with copper by electroplating. In such cases, the substrate may be a laminate. It will generally comprise a polymer or a fiber reinforced polymer matrix.

There are many advantages in fabricating the vias using via post rather than the drill-fill technology. In via post technology, since all vias may be fabricated simultaneously, whereas holes are drilled individually, the via post technology is faster. Furthermore, since drilled vias are cylindrical whereas via posts may have any shape. In practice all drill-fill vias have the same diameter (within tolerances), whereas via posts may have different shapes and sizes. Also, for enhanced stiffness, preferably the polymer matrix is fiber reinforced, typically with woven bundles of glass fibers. Where fiber in polymer prepreps are laid over upstanding via posts and cured, the posts are characterized by smooth, vertical sides. However, drill-fill vias typically taper somewhat and, where a composite is drilled, typically have rough surfaces which result in stray inductances that cause noise.

Generally, the vias **14** are in the range of 25 micron to 500 micron wide. If cylindrical, such as required for drill-fill and such as is often the case for via posts, each via may have a diameter in the range of 25 micron to 500 micron.

With further reference to FIG. 3, after fabricating the polymer matrix framework **16** with embedded vias, the sockets **12** may be fabricated by CNC or punching. Alternatively, using either panel plating or pattern plating, sacrificial copper blocks may be deposited. If the copper via posts **14** are selectively shielded, using a photoresist, for example, such copper blocks may be etched away to create the sockets **12**.

A polymer framework of a socket array **38** with vias **14** in the frame **38** around each socket **12** may be used for creating individual and multiple chip packages, including multiple chip packages and built up multilayer chip packages.

Once the chips **35** are positioned in the sockets **12**, they may be fixed in place using a packaging material **36**, that is typically a polymer, such as a molding compound, a dry film B-stage polymer or a prepreg.

With reference to FIG. 4, copper routing layers **42, 43** may be fabricated on one or both sides of the framework **40** embedded with chips **35**. Typically, the chips **35** are laid with terminations face downwards and are coupled to pads **43** that fan out beyond the edges of the chip **35**. By virtue of the through vias **14**, pads **42** on the upper surface and pads **43** on the lower surface allow coupling a further chips by flip chip, wire bonding assembly processes or BGA (Ball Grid Array) soldering process of IC substrate packages in what is known as PoP (Package on Package) and the like. It should also be noted that coupling chips or IC substrate packages is also possible directly to external ends of the via **14** in some cases. Essentially, it will be appreciated that the upper and lower pads **42, 43** enable building up further via posts and routing feature layers to create more complex structures and that such complex structures can still accommodate chip of or IC substrate packages on their outermost feature layers or via layers exposed on their surfaces.

A dicing tool **45** is shown. It will be appreciated that the array of packaged chips **35** in the panel **40** may be easily diced into individual chips **48** as shown in FIG. 5, using a rotary saw or a laser, for example.

Referring to FIG. 6, in some embodiments, adjacent chip sockets may have different dimensions, including different sizes and/or different shapes. Furthermore, a package may include more than one chip, and may include different chips. For example, a processor chip **35** may be positioned in one socket and coupled to a memory chip **55** positioned in an adjacent socket, the two chips being separated by a bar consisting of the frame material.

Conductors of the routing layer **42, 43** may couple to terminations of the chips via. At the current state of the art, via posts may be about 130 microns long. Where the chips **35, 55** are thicker than about 130 microns, it may be necessary to stack one via on top of another. The technology for stacking vias is known, and is discussed, inter alia, in co-pending applications U.S. Ser. No. 13/482,099 and U.S. Ser. No. 13/483,185 to Hurwitz et al.

With reference to FIG. 7, a die package **48** comprising a die **55** in a polymer frame **16** is shown from below, such that the die **55** is surrounded by the frame **16** and through vias **14** are provided through the frame **16** around the perimeter of the die **55**. The die is positioned in a socket and held in place by a packaging material **36** that is typically a second polymer. The frame **16** is typically fabricated from a fiber reinforced prepreg for stability. The second polymer of the packaging material **36** may be a polymer film or a molding compound. It may include fillers and may also include chopped fibers. Typically, as shown, the through vias **14** are simple cylindrical vias, but they may have different shapes and sizes. Some of the ball grid array of solder balls **57** on the chip **55** are connected to the through vias **14** by pads **43** in a fan out configuration. As shown, there may be additional solder balls that are coupled directly to a substrate beneath the chip. In some embodiments, for communication and data processing, at least one of the through vias is a coaxial via. Technologies for manufacturing coaxial vias are given in co-pending application U.S. Ser. No. 13/483,185, for example.

In addition to providing contacts for chip stacking, through vias **14** surrounding a chip may be used to isolate the chip from its surroundings and to provide Faraday shielding. Such shielding vias may be coupled to pads that interconnect the shielding vias over the chip and provide shielding thereto.

There may be more than one row of through vias surrounding the chip, and the inner row could be used for signaling and the outer row for shielding. The outer row could be coupled to a solid copper block fabricated over the chip that could thereby serve as a heat sink to dissipate heat generated by the chip. Different dies may be packaged in this manner.

The embedded chip technology with a frame having through vias described herein is particularly suited for analog processing, since the contacts are short, and there are a relatively small number of contacts per chip.

It will be appreciated that the technology is not limited to packaging IC chips. In some embodiments, the die comprises a component selected from the group consisting of fuses, capacitors, inductors and filters. Technologies for manufacturing inductors and filters are described in co-pending application number U.S. Ser. No. 13/962,316 to Hurwitz et al.

With reference to FIGS. 8A-B, and FIGS. 8(a) to 8(v), a method of embedding chips in an organic insulator comprises: fabricating a grid **120** of chip sockets **126** each defined by an organic matrix frame **122** that further comprises at least one via **124** through the organic matrix frame **122**—8(a). As shown, the organic matrix frame is a glass reinforced dielec-

11

tric with embedded via posts, for example with the sockets punched out or machined out using CNC. Alternatively, the sockets could be fabricated by electroplating copper and dissolving whilst protecting the via posts. Alternatively, the sockets could be punched out of a laminate having plated through holes,

The grid of chip sockets **120** is positioned on a tape **130**—**8(b)**. The tape **130** is generally a commercially available transparent film that may be decomposed by heating or by exposure to ultra-violet light.

Dies **132** are positioned face down in the sockets **126** of the grid **120**—**8(c)**, and may be aligned by imaging through the tape. The positioning of the dies **132** in the sockets **126** is typically fully automated. A packaging material **134** is placed over the dies **132** and the grid **120**—**8(d)**. In one embodiment, the packaging material **134** is a dielectric film that is 180 microns thick and the dies **132** are 100 microns thick. However, dimensions may vary somewhat. The packaging material **134** typically has a thickness of from about 150 microns to several hundred microns. The packaging material **134** may be a molding compound. The dies **132** typically have a thickness of from 25 microns to hundreds of microns. It is important that the thickness of the packaging material **134** exceeds that of the dies **132** by several tens of microns.

The dielectric material **122** of the frame **120** and the packaging material **134** applied over the chips **132** may have a similar matrix, or the polymer matrix may be very different. The frame typically comprises continuous reinforcement fibers which may be provided as a prepreg. The packaging material **134** does not include continuous fibers but may include chopped fibers and/or particle fillers,

A carrier **136** is applied over the dielectric **134**—**8(e)**. The tape **130** is removed—**8(f)**, exposing the underside of the chips **132**. Depending on the specific tape used, tape **130** may be burned away or removed by exposure to ultraviolet light. A seed layer **138** (typically titanium and then copper) is sputtered over the dielectric—**8(g)**. Alternative seed layers for enhanced adhesion of the electroplated copper to the polymer include chrome and nickel chrome alloy. A layer of photo resist **140** is applied and patterned—step **8(h)**. Copper **142** is electroplated into the pattern—**8(i)**. The dielectric film or photo resist **140** is stripped away—**8(j)**, and the sputter layer(s) **138** is (are) etched away—**8(k)**. Then, an etch barrier **144** is applied over the copper and underside of the chips—**8(l)**. The etch barrier **144** may be a dry film or photo resist. The copper carrier **136** is etched away—step **8(m)** using copper chloride or ammonium hydroxide, for example. The construction is thinned to expose frame and end of via—step **8(n)**, optionally, using a plasma etch, such as CF_4 and O_2 in a ratio in the range of 1:1 to 3:1, for example. The plasma etch may be followed by a Chemical Mechanical Polishing (CMP). An adhesive metal seed layer **146**, such as titanium (or chrome, or nickel chrome alloy) is sputtered over the thinned polymer **134**—**8(o)** followed by a copper seed layer **148**—**8(p)**. A layer of photo resist **150** may then be applied—**8(q)** and patterned **152**—step **8(r)**. Copper **154** is then electroplated into the pattern **152** to form a pattern of conductor features that contacts the copper vias **124**—step **8(s)**, and the photo resist is stripped away from both sides—step **8(t)**. The seed layers **146**, **148** are removed—**8(u)** and the array is segmented **8(v)**. The segmenting or dicing may be accomplished using a rotary saw blade or other dicing technique, such as a laser, for example.

It will be appreciated that once there is a routing layer of copper conductor features **142**, **146** on a side of the substrate, it is possible to attach chips to the conductor features with ball grid array (BGA) or land grid array (LGA) technologies.

12

Furthermore, it is possible to build up further routing layers. In the construction described, there are routing layers of conductor features **142**, **146** on both sides. Thus further layers may be built up on either or both sides, enabling package on package “PoP” and similar constructions.

With reference to FIG. 9, the heart of the invention is a structure **200** consisting of an array of embedded dies **202**, each positioned with the side with the contacts **204** downwards, in a socket of a frame **206** fabricated from a dielectric material that is typically a fiber reinforced polymer, wherein the dies **202** are encapsulated with a packing material **208** that is typically a polymer, that bonds the dies **202** to the frame **206** and that covers the opposite face of the die **202** to the face with the contacts **204**. There is at least one through via **210**, and typically a plurality of through vias **210** embedded in the frame **208** surrounding each die **202**, such that the ends of the through vias **210** are exposed on both sides of the structure, enabling further build up. The vias **210** may be via posts that are fabricated by pattern electroplating or by panel electroplating and selective etching to remove excess metal, typically copper. If necessary, such as where the depth of the frame is too much to be fabricated in one plating procedure, the vias **210** may be stacks of shorter via posts, optionally with pads there-between. The vias may alternatively be plated through holes, (Pth) fabricated by drill & fill technology.

Typically the structure **200** is fabricated by first fabricating a frame **206** by either laminating polymer dielectric over via posts or by drilling and copper plating through holes in a copper clad dielectric panel, typically a laminate and then removing the cladding. Sockets are then fabricated in the substrate with embedded through vias, by etching selectively copper via post blocks or by CNC or simply by punching. Dies **202** are placed in each socket using removable tape as membrane under the frame, contacts **204** downwards, and the dies are encapsulated with a packing material **208**, which is typically a polymer, and may be a molding compound or a polymer film or pre-preg. The packing material may include inorganic fillers such as chopped fibers or ceramic particles. The tape is removed and top dielectric polymers are etched down to expose vias ends and die pads.

Thus persons skilled in the art will appreciate that the present invention is not limited to what has been particularly shown and described hereinabove. Rather the scope of the present invention is defined by the appended claims and includes both combinations and sub combinations of the various features described hereinabove as well as variations and modifications thereof, which would occur to persons skilled in the art upon reading the foregoing description.

In the claims, the word “comprise”, and variations thereof such as “comprises”, “comprising” and the like indicate that the components listed are included, but not generally to the exclusion of other components.

What is claimed is:

1. A method of fabricating embedded die packages comprising:
 - obtaining an array of chip sockets such that each chip socket is surrounded by a framework having a polymer matrix of a first polymer and at least one via post through the framework around each socket;
 - Placing said array with framework on a transparent tape so that an underside of the array of chip sockets contacts said transparent tape;
 - positioning a chip terminal side down in each chip socket so that undersides of said chips contact said transparent tape;
 - Aligning said chips with said via posts by optical imaging through the tape;

13

Applying a packing material over and around said chips in said array, and curing the packing material to embed the chips on five sides;
 Thinning and planarizing the packing material to expose upper ends of said vias on upper side of said array;
 Removing the transparent tape;
 Applying a feature layer of conductors on said underside of said array of chip sockets and said undersides of the chips, to couple at least one terminal of each die to at least one through via;
 Applying a feature layer of conductors on over side of said array of chip sockets such that at least one conductor extends from a through via at least partway over each chip, and
 dicing said array to create separate dies comprising at least one embedded chip having a contact pad coupled to a through via adjacent said chip.

2. The method of claim 1, wherein said array comprises an array of oblong cells.

3. The method of claim 1, wherein the chips comprise at least one of analog processors, digital processors, sensors, filters and memories.

4. The method of claim 1, wherein the framework comprises glass fiber reinforcements in said first polymer.

5. The method of claim 1, wherein the framework comprises a weave of glass fiber bundles in said first polymer.

6. The method of claim 1, wherein the packing material comprises a second polymer matrix.

7. The method of claim 1, wherein the packing material comprises a molding compound.

8. The method of claim 1, wherein the packing material comprises at least one polymer sheet that is laid over the framework and chips and is hot pressed.

9. The method of claim 6 wherein the packing material further comprises at least one of a particle filler and a chopped fiber filler.

10. The method of claim 1, wherein the array of chip sockets is fabricated by:
 obtaining a sacrificial carrier;
 laying down a layer of photoresist;
 patterning the photoresist with a grid of copper vias;
 plating copper via posts into the grid;
 Stripping away the photoresist
 laminating the copper via posts with a polymer dielectric;
 thinning and planarizing the polymer dielectric to expose ends of the copper vias;
 removing the carrier, and
 machining chip sockets in the polymer dielectric.

14

11. The method of claim 10, wherein the sacrificial carrier is a copper carrier that is removed by dissolving the copper.

12. The method of claim 10 further comprising applying an etch-resistant layer over the carrier prior to depositing copper vias.

13. The method of claim 10, wherein the planarized polymer dielectric with exposed ends of copper vias is protected with an etch resistant material whilst the copper carrier is etched away.

14. The method of claim 13 wherein the etch resistant material is a photoresist.

15. The method of claim 11 wherein the polymer dielectric further comprises a weave of bundles of glass fibers and is applied as a pre-preg and is then cured.

16. The method of claim 1, wherein the array of chip sockets is fabricated by:
 obtaining a sacrificial carrier;
 laying down a layer of photoresist;
 patterning the photoresist with a grid of copper vias and with an array of sockets;
 plating copper via posts into the grid and the array;
 Stripping away the photoresist;
 laminating the copper via posts and the array with a polymer dielectric;
 thinning and planarizing the polymer dielectric to expose ends of copper vias and array;
 shielding the ends of the copper vias and selectively dissolving the array to form the sockets, and
 removing the carrier.

17. The method of claim 1, wherein the honeycomb array is fabricated by:
 obtaining a substrate comprising a copper clad polymer matrix;
 drilling an array of via holes;
 electroplating copper into the via holes;
 removing copper cladding, and
 machining sockets through the substrate.

18. The method of claim 17 wherein the step of removing the copper cladding comprises at least one of dissolving, abrasion and plasma etching.

19. The method of claim 17 wherein the polymer matrix further comprises glass fibers.

20. The method of claim 17 wherein the step of machining away sockets comprises at least one of punching and CNC.

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